

Work Order ID 58503

Friday, May 07, 2010 2:30:28 PM



Page 1

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Assembly, Aft

Stop



Start Date: 5/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-5-17 Tooling:

Date:

Run Start



QC:

Date: _____ SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr Revision Nbr

100 B

100 Pick Kit 0.00



Packaging

Memo

Packaging

EJ 10/05/12 (6)

110



Small Fab

Memo

Small Fab

1- Assemble as per dwg
TRIM RIVETS 1.185" LONG

EJ 10/05/12 (6)

120



QC5- Inspect part completeness to step on W/O

QC

Memo

Quality Control

0.00

S. Jolustia

(6)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
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Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: VM6

0.00

10-5-12 6x10

Packaging

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

10/05/13 MF

QC

Quality Control

Memo

0.00

10-5-12

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Picklist Print

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Work Order ID: 58503



Parent Item: D3908-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 5/10/2010

Required Date: 5/13/2010

Comments: IPP RevA: New issue DD verified by:EC
As per Rev B 10-04-06 VERIFIED BY:DD

IPP REV B:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2690-6		Manufactured	No			100	Each	0.0000		1		

Lanyard Assembly

D3908-1



Manufactured

No

358375 (6)



EP10/05/12

Lug Plate, Aft Crosstube

D3908-3



Manufactured

No

Location

Loc Qty

Loc Code

ST095

35

57815

7

58344

28

100

Each

2.0000

1



EP10/05/12

Stud Receiver, Lower

D3908-5



Manufactured

No

Location

Loc Qty

Loc Code

ST095

2

358345 (6)

57816

2

100

Each

13.0000

1



EP10/05/12

Eyebolt Stud

Location

Loc Qty

Loc Code

GA

1

57428

1

ST095

12

58347

12



EP10/05/12

6

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Required Date: 5/13/2010

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Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3910-1		Manufactured	No			100	Each	12.0000	2		<i>5/10/12</i>	

Crosstube Lug

<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>
ENG	57194	11	<i>11</i>
st507	58353	1	<i>1</i>
		1	<i>1</i>

AN3C12A



Purchased No

100 Each 176.0000



Bolts

<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>
ST351	112314	176	<i>24</i>
		176	<i>24</i>

MS17984-C413



Purchased No

100 Each 27.0000



PIN, QUICK RELEASE

<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>
ST297	114340	4	<i>6</i>
ST314	114495	23	<i>6</i>
	114523	3	<i>6</i>
		20	<i>6</i>

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Required Date: 5/13/2010

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As per Rev B 10-04-06 VERIFIED BY:DD

IPP REV B:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS20615-4M120 4M18						100	Each	204.0000	6		EP 10/05/12	

RIVET

1114506 (36x)

Location Loc Qty Loc Code

ST323	204	
113254	16	
114324	4	
114349	184	

MS21043-3



Purchased No

100 Each 3,735.000



EP 10/05/12

Nut

Location Loc Qty Loc Code

FG	80	
103691	80	
ST301	3655	
112314	3655	

NAS1149C0332R



Purchased No

100 Each 3,238.000



EP 10/05/12

Washer

Location Loc Qty Loc Code

ST297	3238	
113524	10	
113737	150	
114341	3078	

48

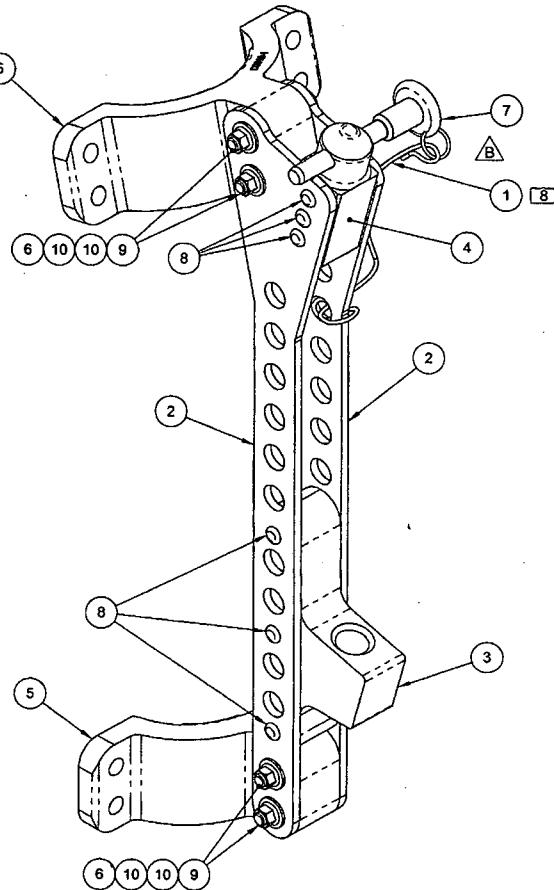
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ITEM	QTY.	P/N	DESCRIPTION
X	1	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	4	AN3C12A	BOLT
7	1	MS17984-C413	PIP PIN
8	6	MS20615-4M20	RIVET
9	4	MS21043-3	NUT
10	8	NAS1149C0332R	WASHER



*58503

RELEASED
2010-04-14
MP

D3908-041 X-TUBE LUG ASSY (AFT)

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 2.35 lbs
 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

B	BOM: D3908-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 5: ADDED D3908-5			JPH	10.04.06
A	NEW ISSUE			JPH	10.03.04
REV.	DESCRIPTION	BY	DATE		
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			A
DRAWN	JPH	DRAWING NO.	D3908	REV. B	
CHECKED		MFG. APPR.		SHEET 1 OF 5	
APPROVED		DE APPR.		SCALE	
DATE	10.04.06			NTS	

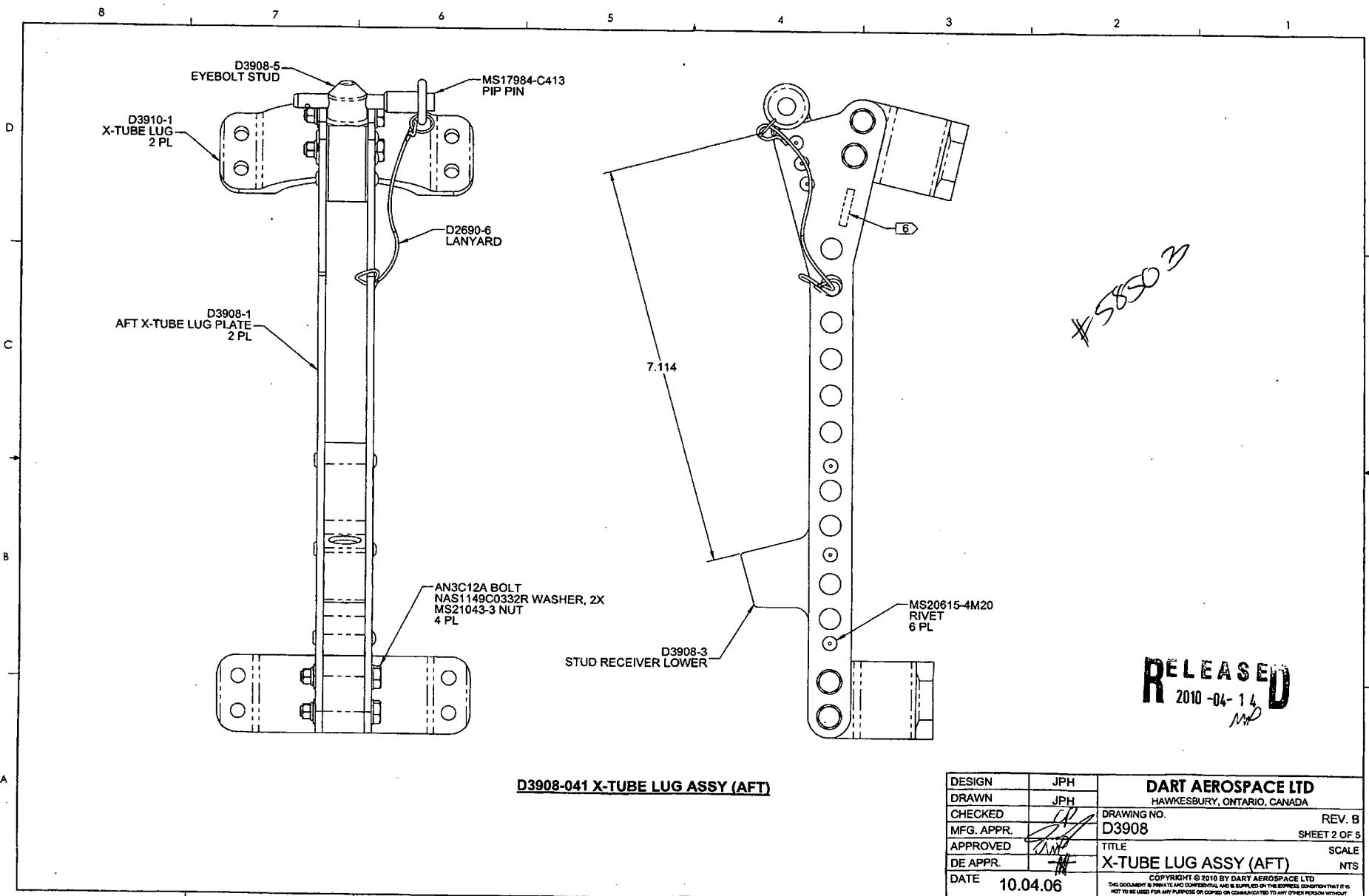
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DESIGN	JPH	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>JPH</i>	DRAWING NO. D3908
MFG. APPR.		REV. B
APPROVED	<i>JPH</i>	SHEET 2 OF 5
DE APPR.	<i>JPH</i>	TITLE X-TUBE LUG ASSY (AFT)
DATE	10.04.06	SCALE NTS

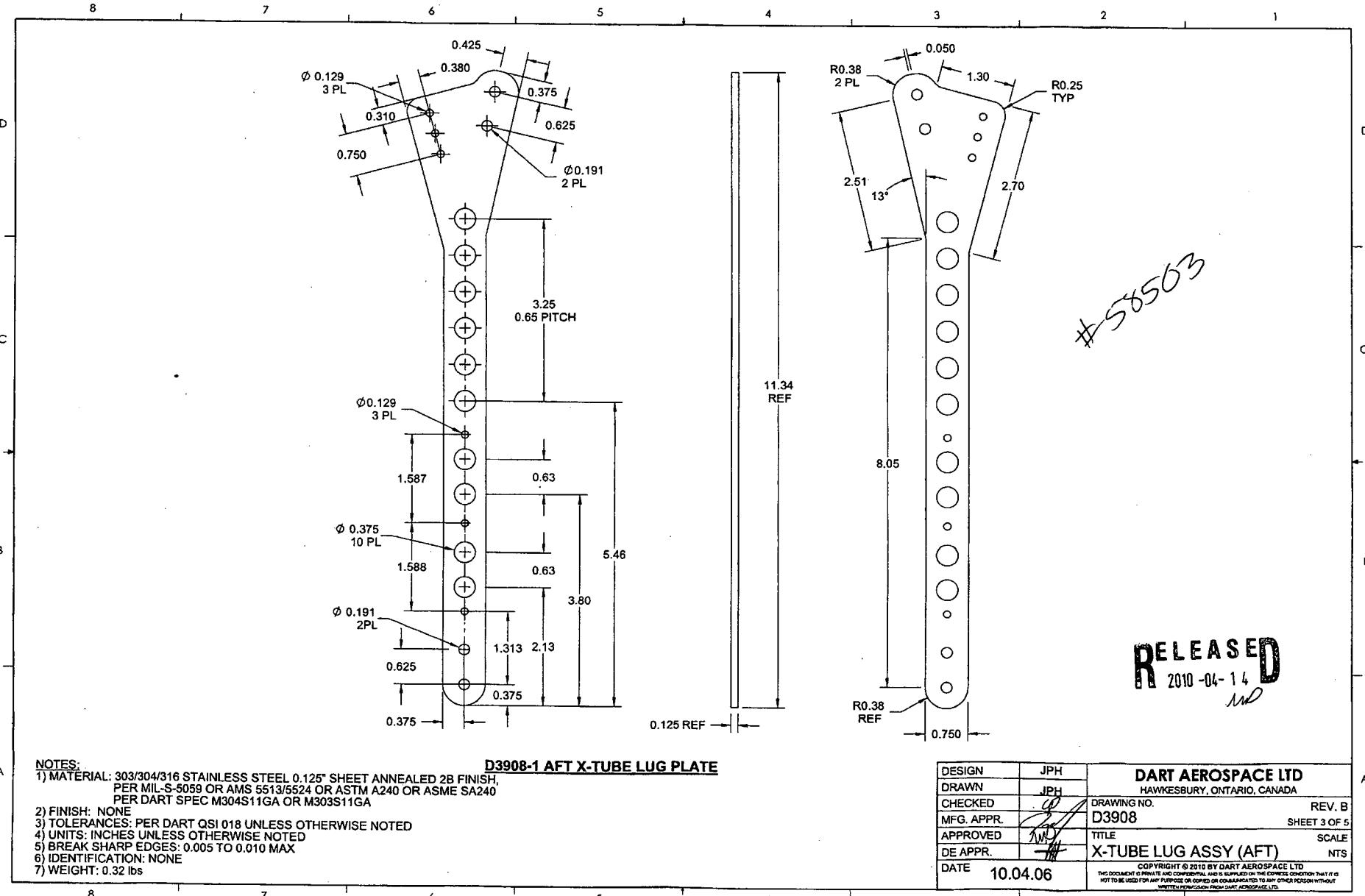
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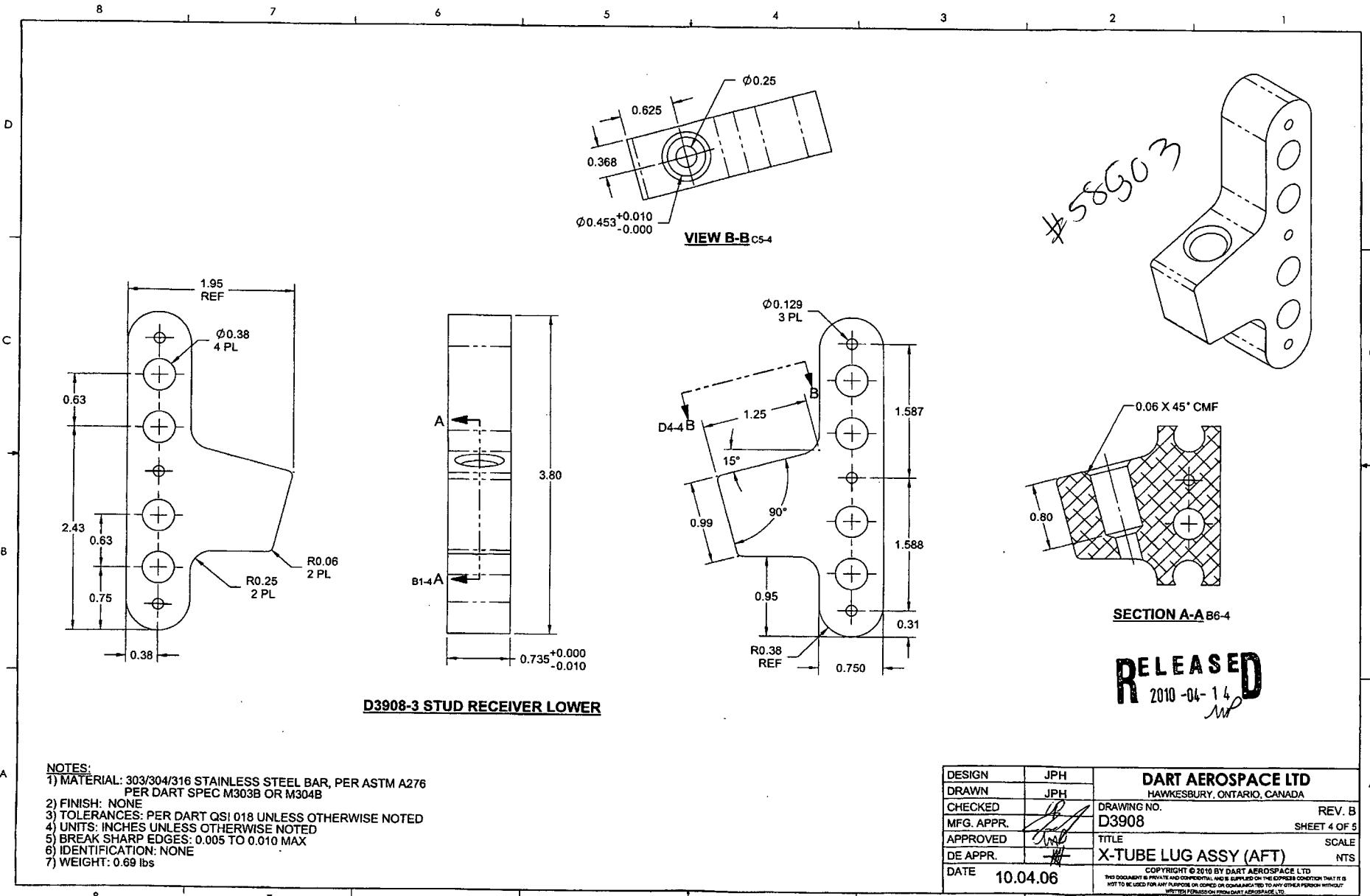


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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JPH</i>	DRAWING NO. D3908	
MFG. APPR.	<i>JPH</i>	REV. B	
APPROVED	<i>JPH</i>	SHEET 4 OF 5	
DE APPR.	<i>JPH</i>	TITLE X-TUBE LUG ASSY (AFT)	
DATE	10.04.06	SCALE NTS	

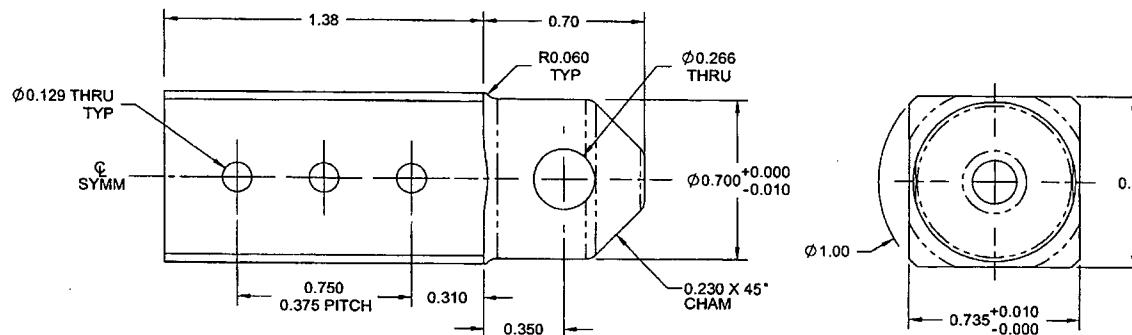
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D3908-5 EYEBOLT STUD



NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JPH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JPH</i>	D3908	SHEET 5 OF 5
APPROVED	<i>JPH</i>	TITLE	SCALE
DE APPR.	<i>JPH</i>	X-TUBE LUG ASSY (AFT)	
DATE	10.04.06	NTS	

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RELEASED

2010-04-14

MP

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